



Dart Aerospace Ltd.
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K6A 1K7
Canada

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005019

D205-633-013
Job Sheet 181712



Part No: D205-633-013

Job Qty: 2 ea

Part Name: Heli-Access-Step™ - 31" Extended Height Gear, Isolair Tank Comp., Fits LH or RH



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 8/7/18

Job Tracking No:

Due Date: 9/3/18

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG REV C SHEET 17 IPP Rev:F 02.07.11 Reformat; Removed D3010 RF IPP rev G 07.08.22 Added hardware per DSI9302-013 EC IPP REV:H 11.01.12 AS PER DSI 9540 REV.A DD VERF:EC

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	2 Ea	9/3/18	9/3/18	0.00	0.00	Start Up Stores/Pkg-1		AUG 16 2018
110	Packaging	2 pcs	9/3/18	9/3/18	0.00	0.00	Packaging1-2		AUG 16 2018
120	QC	2 pcs	9/3/18	9/3/18	0.00	0.00	QC4		DAS 69
125	DC	2 pcs	9/3/18	9/3/18	0.00	0.00	DC		DAS 69
130	Packaging	2 pcs	9/3/18	9/3/18	0.00	0.00	Packaging3-1		DAS 69
140	QC21-FG	2 Ea	9/3/18	9/3/18	0.00	0.00	QC21		9-89

Part Op 125 - Photocopy bluefile & type labels per PPP D205-633-013 CHG002

Descriptions: 130 - Identify and pack for shipping as per PPP D205-633-013 Location : FG082

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
AN4-10A	Bolt	2 Ea (1 ea)	90-Start up Operation	FM137412-0
AN4-14A	Bolt	2 Ea (1 ea)	90-Start up Operation	5067888
AN4-5A	Bolt	2 Ea (1 ea)	90-Start up Operation	5027725
AN4-6A	Bolt	6 Ea (3 ea)	90-Start up Operation	5058982
AN4-7A	Bolt	4 Ea (2 ea)	90-Start up Operation	5057520
AN44-7A	Eyebolt	2 Ea (1 ea)	90-Start up Operation	5067889
AN5-14A	Bolt	2 Ea (1 ea)	90-Start up Operation	5056344
D2022-101	Spacer	4 Ea (2 ea)	90-Start up Operation	5071656
D2022-103	Spacer	4 Ea (2 ea)	90-Start up Operation	5071112
D2562-013	Strut 26.63"	2 Ea (1 ea)	90-Start up Operation	5078572
D2563	Step Weldment Assembly	2 Ea (1 ea)	90-Start up Operation	5098421
D2565-201	Strut	2 Ea (1 ea)	90-Start up Operation	5072546
D2565-203	Strut	2 Ea (1 ea)	90-Start up Operation	5071809
D2565-205	Strut	2 Ea (1 ea)	90-Start up Operation	5078511
D2565-207	Strut	2 Ea (1 ea)	90-Start up Operation	5072615
D2565-209	Strut	2 Ea (1 ea)	90-Start up Operation	5071024
D2565-211	Strut	2 Ea (1 ea)	90-Start up Operation	5071371
MS21042L4	Nut	16 Ea (8 ea)	90-Start up Operation	5089365
MS21042L5	Nut	4 Ea (2 ea)	90-Start up Operation	5083541
NAS1149D0463J	Washer	32 Ea (16 ea)	90-Start up Operation	5089299
NAS1149D0563J	Washer	6 Ea (3 ea)	90-Start up Operation	5093773

DQA: _____ Date: _____

**WORK ORDER NON-CONFORMANCE / UPDATE**

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width:100%; border: none;"> <tr> <td style="border: none;">Skid-tube ☐</td> <td style="border: none;">Cross tube ☐</td> <td style="border: none;">Water Jet ☐</td> <td style="border: none;">Engineering ☐</td> </tr> <tr> <td style="border: none;">Machining ☐</td> <td style="border: none;">Small Fab ☐</td> <td style="border: none;">Prod. Eng. Coord. ☐</td> <td style="border: none;">Quality ☐</td> </tr> <tr> <td style="border: none;">Thermoforming ☐</td> <td style="border: none;">Finishing ☐</td> <td style="border: none;">Rec/Store/Packaging ☐</td> <td style="border: none;">Other ☐</td> </tr> <tr> <td style="border: none;">Large Fab ☐</td> <td style="border: none;">Composite ☐</td> <td style="border: none;">Supplier ☐</td> <td></td> </tr> </table>				Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐																																																						
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DART Aerospace Ltd. 1270 Aberdeen Street Hawkesbury, ON K6A 1K7 CANADA TEL.: 1 813 832-5200 Email: sales@dartaero.com www.dartaerospace.com Container No: S102864 Part: D205-633-013 Job No: 181712 Serial No/Batch: S102864 Revision: Inspector: Exp Date: Instructions: TC STC SH96-57 Issue 5, FAA STC SR00592NY 03/08/01, FAA STI				Lead hand / Supervisor Approval Verification																																																																						
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Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	AN4-10A	2	123	0
	AN4-14A	2	473	0
	AN4-5A	2	221	0
	AN4-6A	6	1,474	0
	AN4-7A	4	84	0
	AN44-7A	2	5	0
	AN5-14A	2	74	0
	D2022-101	4	11	0
	D2022-103	4	9	0
	D2562-013	2	2	0
	D2563	2	4	0
	D2565-201	2	2	0
	D2565-203	2	2	0
	D2565-205	2	4	0
	D2565-207	2	3	0
	D2565-209	2	3	0
	D2565-211	2	2	0
	MS21042L4	16	6,206	0
	MS21042L5	4	1,112	0
	NAS1149D0463J	32	10,343	0
	NAS1149D0563J	6	2,086	0

Part Specifications

Specifications could not be found.

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

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Date :	Step #:	QTY Effective :		MRB (QSI042) Approval	
Description Work Order Deviation			Disposition		
			Completed By		
			Lead hand / Supervisor Approval Verification		
			QC / QA Coordinator Approval		
Root Cause		FAULT CATEGORY			
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐
OTHER : ☐					

REFERENCE ONLY

5.0 PARTS LISTS

5.1 D205-633-011/-013/-015/-017 Heli-Access Step

QTY -011	QTY -013	QTY -015	QTY -017	Part Number	Description
X				D205-633-011	Heli-Access-Step™, High Gear
	X			D205-633-013	Heli-Access-Step™, Extended High Gear (31")
		X		D205-633-015	Heli-Access-Step™, Extended High Gear (39")
			X	D205-633-017	Heli-Access-Step™, Standard Low Gear
1			1	D2021-101	EYEBOLT
2	2	2	2	D2022-101	SPACER
2	2	2	2	D2022-103	SPACER
1				D2562-001	STRUT
		1		D2562-005	STRUT
			1	D2562-007	STRUT
	1			D2562-013	STRUT
1	1	1	1	D2563	WELDMENT ASSEMBLY
1				D2565-101	STRUT
1				D2565-103	STRUT
1				D2565-105	STRUT
1				D2565-107	STRUT
1				D2565-109	STRUT
1				D2565-111	STRUT
	1			D2565-201	STRUT
	1			D2565-203	STRUT
	1			D2565-205	STRUT
	1			D2565-207	STRUT
	1			D2565-209	STRUT
	1			D2565-211	STRUT
		1		D2565-301	STRUT
		1		D2565-303	STRUT
		1		D2565-305	STRUT
		1		D2565-307	STRUT
		1		D2565-309	STRUT
			1	D2565-401	STRUT
			1	D2565-403	STRUT
			1	D2565-405	STRUT
			1	D2565-407	STRUT
			1	D2565-409	STRUT
			1	D2565-411	STRUT
		1		D3165-1	SUPPORT ARM
	1	1		AN44-7A	EYEBOLT
2	1	1	2	AN4-5A	BOLT
2	3	3	2	AN4-6A	BOLT
2	2	2	2	AN4-7A	BOLT
1	1	1	1	AN4-14A	BOLT
	1	1		AN4-10A	BOLT
1			1	AN5-6A	BOLT
1	1	1	1	AN5-14A	BOLT
15	16	16	15	AN960JD416	WASHER
4	3	3	4	AN960JD516	WASHER
8	8	8	8	MS21042L4	NUT (or MS21042-4)
2	2	2	2	MS21042L5	NUT (or MS21042-5)

REFERENCE ONLY

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Revision: C

Date: 13.12.13